

5/19

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	23004
<b>Description:</b> Replacement Window Assembly		<b>Part Number:</b>	D3290-041
<b>Dwg:</b> D3290 Rev. A		<b>Qty:</b>	8
Page 1 of 1			

Step	Location	Procedure	By	Date	Qty																
1	DC	Issue Traveler <b>Note: To be made in multiples of 10</b>	RF	05.04.13	10																
2	PG	Issue P/O: <u>2001875</u> Manufacture D3290-1 as per Dwg D3290 Possible Supplier: GFI <b>Material release note is required</b>	U	05.04.13	10																
3	RG	Receive and Inspect for transit damage <b>Ensure material release note is attached</b>	DL	05/07/25	10																
4	QC6	Inspect dimensions as per Dwg D3290	J	05.08.03	10																
5	GA	Deburr	SD	05.08.03	10																
6	FP	Chemical Conversion Coat as per QSI 005 4.1	FF	05.08.03	10																
7	FP	Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3	ML	05 08 08	10																
8	QC3	Inspect Powder Coat	J	05.08.08	10																
9	GA	Assemble as per Dwg D3290 <b>Pick:</b> <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D2126-0780</td><td>Locking Seal</td><td>B23696/B22818</td></tr><tr><td>1</td><td>D3290-1</td><td>Window Frame</td><td>B23004</td></tr><tr><td>1</td><td>D3290-3</td><td>Window</td><td>B23042</td></tr></table>	Qty	Part Number	Description	Batch	1	D2126-0780	Locking Seal	B23696/B22818	1	D3290-1	Window Frame	B23004	1	D3290-3	Window	B23042	SAO	05/08/09	10
Qty	Part Number	Description	Batch																		
1	D2126-0780	Locking Seal	B23696/B22818																		
1	D3290-1	Window Frame	B23004																		
1	D3290-3	Window	B23042																		
10	QC5	Inspect work to Step 9	J	05.08.10	8																
11	ST	Identify and Stock	DL	05/08/11	8																
12	AC	Cost / part: <u>126.18</u>	SAC	05.08.12	8																
13	DC	Close W/O <u>126.18</u> Inspect Level 21	DS	05/08/12	8																

Rev	Date	Change	Revised By	Approved
A	04.08.24	New issue	KJ/JLM	

RELEASED  
04/04/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05-06-10	9	2 <del>1</del> x 03290-3 windows are no good - one has a deep scratch, the others has dust in the window from supplier.	10 05-06-10	Scrap windows, <del>1/1 x 03290-3</del> <del>entire replace 1 cause</del> <del>there's only 1 03290-3</del> <del>left in stock, put 2 x 03290-1</del> back in stock 02126-0780 : Windows in Quarantine x3	2 05-06-11	10 05-06-10	10 05-06-10	2 05-08-10

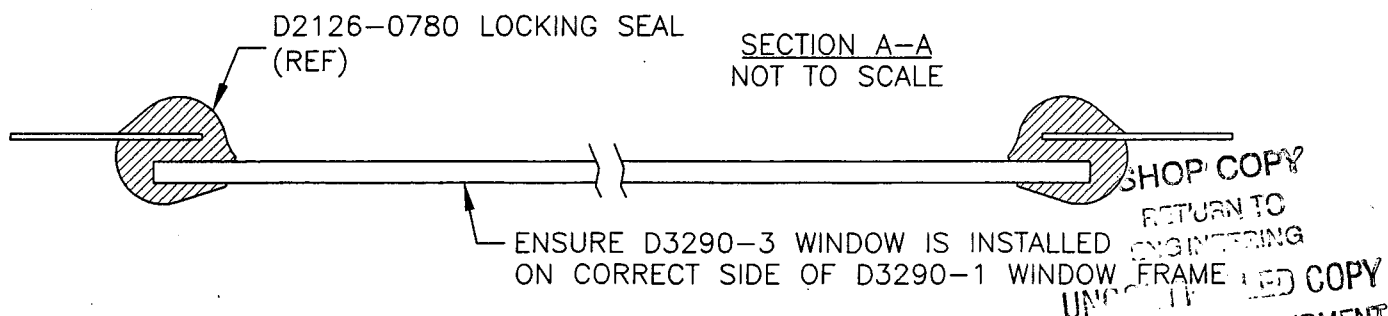
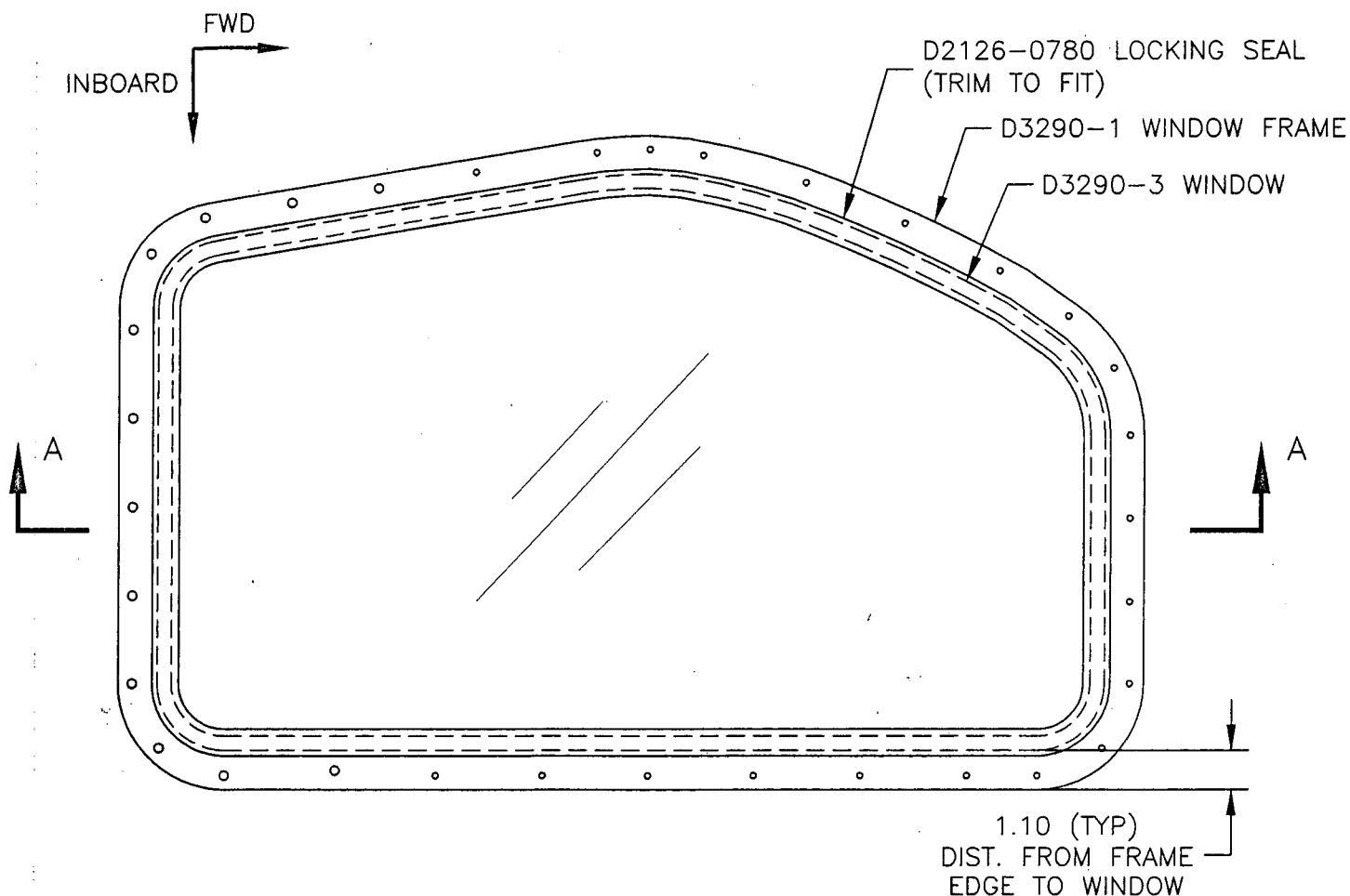
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:   S   Date: 05/08/12

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED UP	APPROVED [Signature]	DRAWING NO. D3290	REV. A SHEET 1 OF 3
DATE 04.06.14	TITLE REPLACEMENT WINDOW ASSEMBLY		SCALE 1:5
A	04.06.14	NEW ISSUE	



**D3290-041**

**NOTES**

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

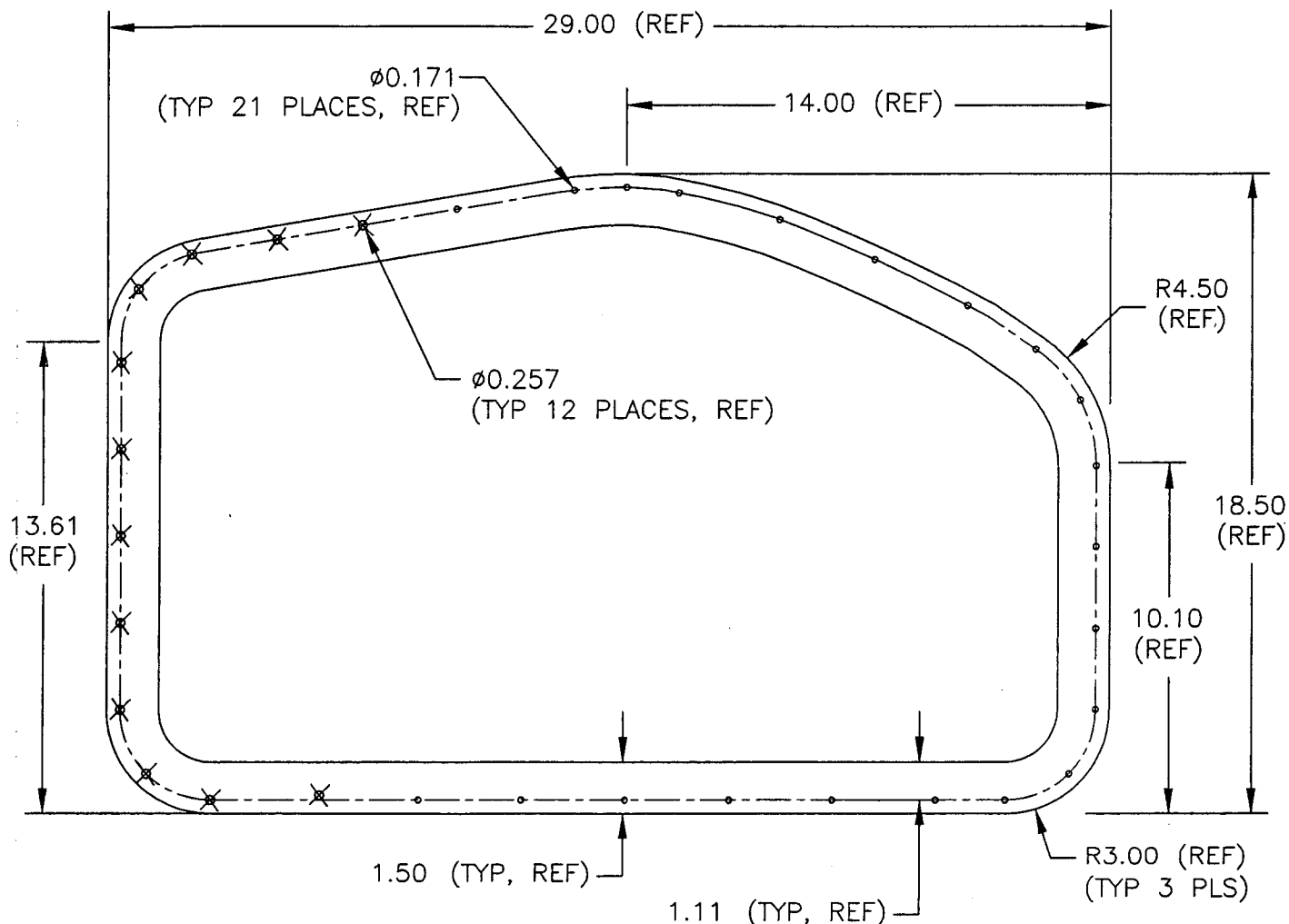
**RELEASED**  
04.07.13  
NO. 23004

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DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED UP	APPROVED RF	DRAWING NO. D3290	REV. A SHEET 2 OF 3
DATE 04.06.14	TITLE REPLACEMENT WINDOW ASSEMBLY		SCALE 1:5



### D3290-1 FRAME

#### D3290-1

- 1) MACHINE PER DRAWING FILE "D3290-A2.DWG"
- 2) MATERIAL: 5052-H32 (QQ-A-250/8) SHEET 0.040 THICK
- 3) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1  
POWDER COAT WHITE (REF. 4.5.3.1) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED  
04.07.14

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S. T. DOCUMENT  
NOTICE

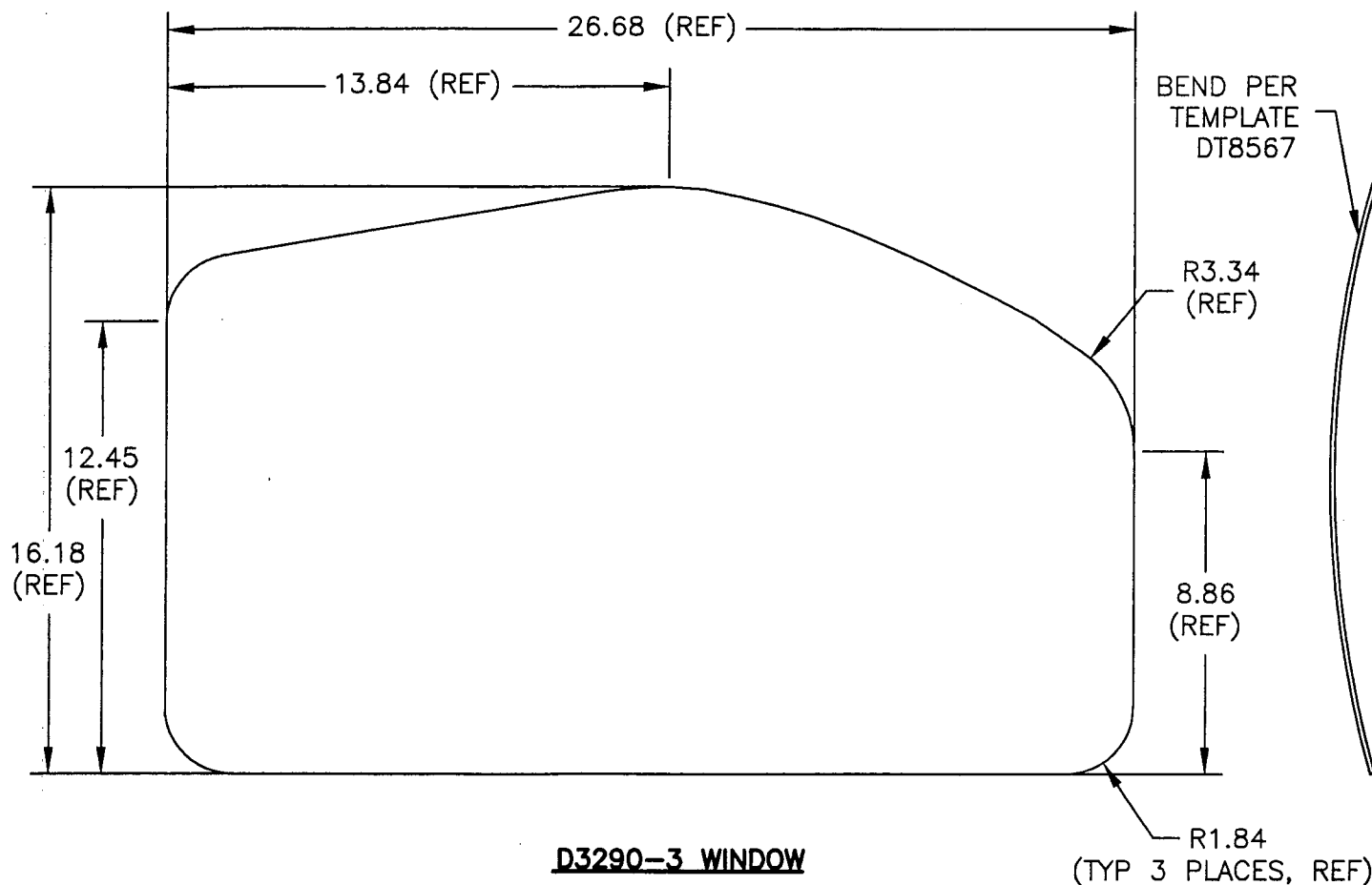
ORDER  
NO. 23004

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DESIGN RT	DRAWN BY JA	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED JA	DRAWING NO. D3290	REV. A SHEET 3 OF 3
DATE 04.06.14		TITLE REPLACEMENT WINDOW ASSEMBLY	SCALE 1:5



#### D3290-3

- 1) MATERIAL: M-ACRYLIC-S.125 (1/8" ACRYLIC SHEET)
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) CHECK PART USING DT3290-3T1

RELEASED  
04.07.12

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FOR INFORMATION  
FOR NOTICE

WORK ORDER  
NO. 23004

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# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Apr 12, 2005  
02:25 pm

Work Order No : 0023004  
Project Name : D3290-041  
Project For : WK519  
Work Order Type : Main  
Main WO Number :  
House Part Number : D3290-041  
Description : Replacement Window Assy  
Manufactured : Yes  
Amount Req'd : 10  
Amount Done : 0  
Start Date : 04-12-05  
Est Finish Date : 05-05-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Mark Up : 0.000%  
Actual Mark Up : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

CERTIFICATE OF COMPLIANCE  
CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE  
POINTE CLAIRE, QC  
H9R 1A1

**DART AEROSPACE LTD**  
1270 ABERDEEN ST.  
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO. 2 OUR JOB NO J0129908 SHIPPING MEMO 0310363

ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
<u>1</u>	<u>10 PCS</u>	<u>2007885</u>	<u>D3290-1</u>		<u>FRAME</u>	<u>A</u>
MATERIAL		SUPPLIED BY		MAT. REL. NO.		
<u>AL 5052-H32</u>		<u>SAMUEL SPECIALTY</u>		<u>0058953 ATT'D</u>		

	PROCESS	PROCESSOR	RELEASE NOTE #
1			
2			
3			
4			
5			
6			
7			
8			
9			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 18 JULY 2005

G.F.I. Q.C. REP. \_\_\_\_\_





Programme d'Assurance Qualité Enregistré / Registered Q.A. Program  
ISO 9001:2000 AS9100

**LETTRE DE CONFORMITÉ --LETTER OF COMPLIANCE**

**Date:** 20 JUIN 2005

**Company Name:** G.F.I. Division of Thomas & Betts limited  
**Address:** 180 avenue Labrosse  
**City:** Pointe Claire, Qué.  
**Zip Code:** H9R 1A1

**# du client:** 0058953  
**Customer's order #:**


**# de commande SSMQ:** 842342  
**SSMQ's Order #:**

La présente est pour certifier que le matériel détaillé ci-dessous est conforme aux exigences de votre commande et des normes du grade tel que décrit:

The following is to certify that the material listed below meets your order requirements and grade standards as described:

Notre/Our Item #	# de pièces/ # of pieces	Épaisseur/Grandeur Gauge/Size	Alliage/Trempe Alloy/Temper	Spécification / Specification	Lot/H.
4	9	.040" X 48" X 96"	5052 H32		1388651

Bien à vous,  
Yours truly,



Commis à l'administration.  
Administration Clerk.





DOC : V/0080134390

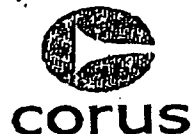
DATE : 2004-11-19

PROD. REF. : 0000166327

NR : 50914/01

PAGE : 1 / 1

INSPECTION CERTIFICATE



CUSTOMER : CORUS ALUMINIUM ROLLED PRODUCTS US

475 N. MARTINGALE ROAD, SUITE 400  
SCHAUMBURG 60173 USAYOUR ORDER NUMBER : P02731 (SAMUEL'S PO# A15790)  
OUR ORDER NUMBER : 50914/01  
DOCUMENT NUMBER : V/0080134390Corus Aluminium N.V.  
A. Stocletlaan 67, 2570 Duffel - Belgium  
Tel. 32 (0)15 30 21 11 - Fax (0)15 30 21 94DESCRIPTION : ALU SHEET 5052-H12 QQA-250/8 AMS 4016 ASTM B209  
DIMENSIONS : 96" X 48" X 0.04"  
ARTICLE NO. :

## CHEMICAL COMPOSITION (%)

COIL  
NUMBERCAST  
NUMBER

	SI	FE	CU	MN	MG	CR	ZN
MIN	0,25	0,40	0,10	0,10	2,2	0,15	0,10
MAX	0,12	0,26	0,01	0,09	2,8	0,35	0,01

002 1388651

OTHERS : EACH : MIN 0,05 MAX  
TOTAL : MIN 0,15 MAX

## MECHANICAL PROPERTIES

TEST-  
NUMBER1 N/MM2 = 1 MPA = 0,1 HBAR = 0,102 KG/MM2 = 0,145 KSI  
/A = REAR END /M = MIDDLE /V = FRONT END /O = RANDOM SAMPLINGMIN  
MAXRM  
KSI  
31  
38RP02  
KSI  
23A  
%  
5

002

/M

33

29

10

1) 282443  
444  
445HEAD OF LABORATORY,  
XAVIER SCHELTJENS